

Work Order ID 81542

81542

Page 1

March-15-12 10:31:13 AM

Item ID: D3499-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cable Guard Assembly
 Start Date: 15/03/2012 Start Qty: ~~6.00~~ ***6*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3499	Rev C

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- assemble per dwg								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

FF
12-04-23
2 0
(72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81542***81542***

Page 2

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Item ID: D3499-042 Accept *N900040100* Setup Start *NS1*
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Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/4/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

March-15-12 10:31:18 AM

Page 1

Work Order ID: 81542

81542

Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 06-05-05 JLM

IPP Rev:B As per Rev B 06-08-31 JLM

IPP Rev:C as

per dwg revC DD 10.02.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C5A

Purchased

No

100

Each

986.0000

2

12

AN3C5A

Bolt

**

2

FF

12-04-23

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

979

116419

28

117343

13

117764

7

117872

2

119749

23

120423

906

121268

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 81542

81542

Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 6.00

Required Qty: 6.00

AN3C6A

Purchased

No

100

Each

599.0000

3

18

AN3C6A

BOLT

**

(2)

FF 12-04-23

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

598

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

109

120693

400

~~20~~ 6

AN960C10L

NAS1149C0332
R

Purchased

No

100

Each

0.0000

10

60

*AN960C10I *

washer

D3499-2

Manufactured

No

100

Each

4.0000

1

6

D3499-2

Mounting Plate

**

20 ~~6~~

(2)

FF 12-04-23

**

(2)

FF 12-04-23

Location

Loc Qty

Loc Code

ST207

4

44903

4

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-15-12 10:31:18 AM

Page 3

Work Order ID: 81542

81542

Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 6.00

Required Qty: 6.00

D3499-3 Manufactured No

D3499-3

Plastic Cable Guard

100 Each 2.0000 1 6

**

81541

~~2~~ 2

(2)

FF 12-04-23

Location

Loc Qty

Loc Code

ST207

2

75365

2

2

D3499-5 Manufactured No

D3499-5

Placard

100 Each 7.0000 2 12

**

(2)

FF 12-04-23

Location

Loc Qty

Loc Code

ST050

7

46759

7

4

D3672-1 Manufactured No

D3672-1

Phenolic Washer

100 Each 1,212.000 5 30

**

(2)

FF 12-04-23

Location

Loc Qty

Loc Code

FP001

208

66821

208

~~10~~ 10

ST060

1004

72229

4

76277

500

80369

500

March-15-12 10:31:18 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-15-12 10:31:18 AM

Page 4

Work Order ID: 81542

81542

Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 6.00

Required Qty: 6.00

MS21043-3

Purchased

No

100

Each

818.0000

5

30

MS21043-3

Nut

(2)

FF 12-04-23

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

316

120693

316

ST301

430

118077

2

118614

378

118686

30

119758

20

121255

10

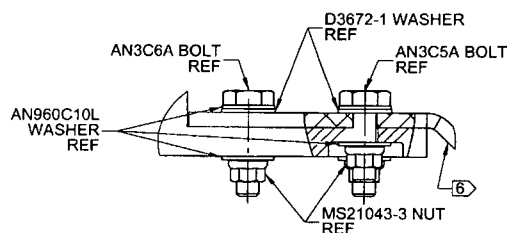
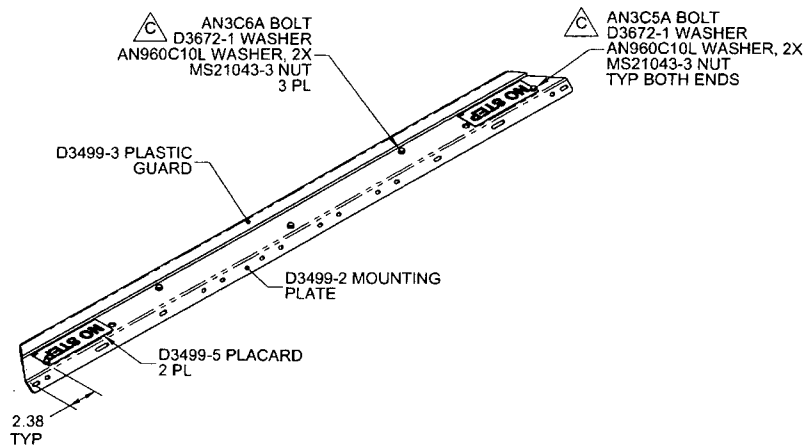
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

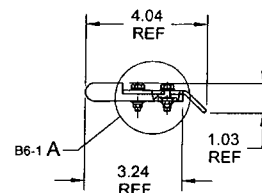
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A
SCALE 4X



D3499-042 CABLE GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3499-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.90 lbs

ITEM	QTY	P/N	DESCRIPTION
1	X	D3499-042	CABLE GUARD ASSEMBLY
2	1	D3499-2	MOUNTING PLATE
3	1	D3499-3	PLASTIC GUARD
4	2	D3499-5	PLACARD
5	2	AN3C5A	BOLT
6	3	AN3C6A	BOLT
7	10	AN960C10L	WASHER
8	5	MS21043-3	NUT
9	5	D3672-1	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81542 MLC

12/03/15

RELEASED
2010-02-02
MD

C	DRAWING UPDATED TO CURRENT STANDARDS. 3.245 WAS 3.255 (ZN B8-3); 3.24 WAS 3.25 (ZN D3-3); REVISE TOLERANCE & 2.01 WAS 2.00 (ZN D3-3); D3672-1 WAS NAS1515H3L (ZN D3-1, D5-1, D7-1); ADD IDENTIFY NOTE (ZN A8-1); REF NCR-09-045	RF	09.06.19
B	RE-DESIGN D3499-2F/-3	MB	06.08.15
A	NEW ISSUE	MB	06.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED			
MFG. APPR.		DRAWING NO.	REV. C
APPROVED		D3499	SHEET 1 OF 1
DE APPR.		TITLE	SCALE
		CABLE GUARD	NTS
DATE	09.06.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

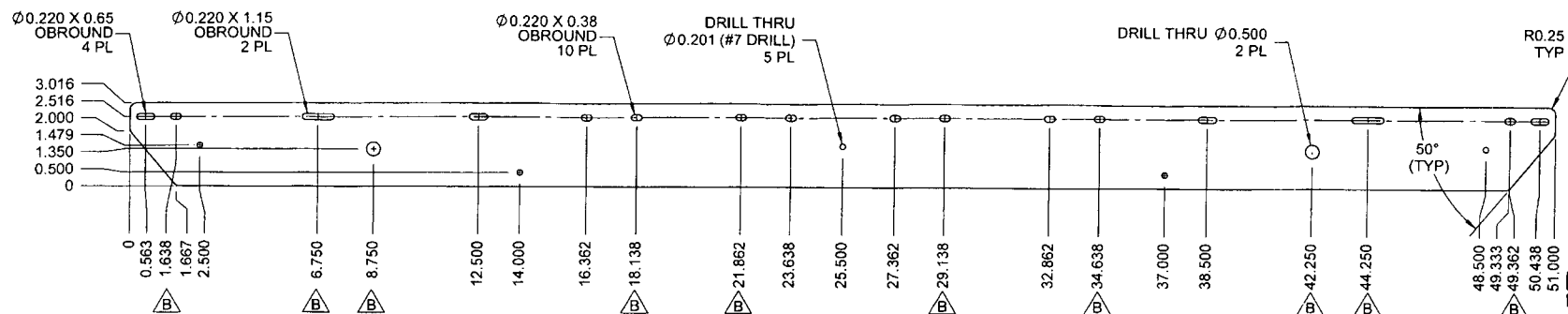
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

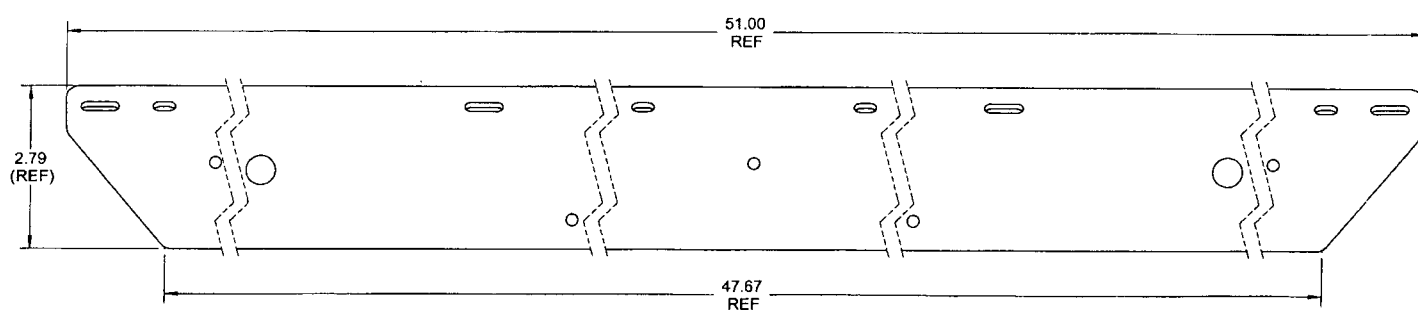
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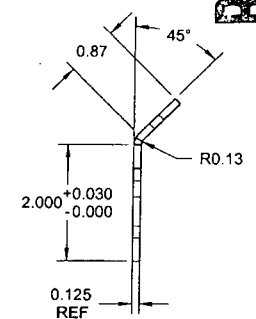
81542



D3499-2F MOUNTING PLATE FLAT PATTERN
SCALE 0.5X



D3499-2 MOUNTING PLATE



D3499-2 BENDING DETAIL

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.81 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3499	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
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RELEASED
R 2010-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

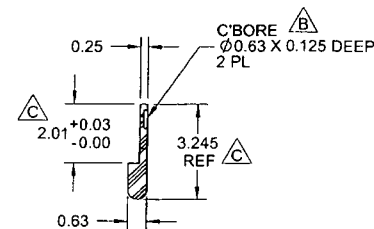
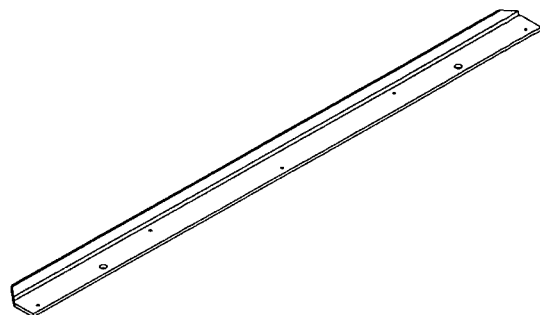
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

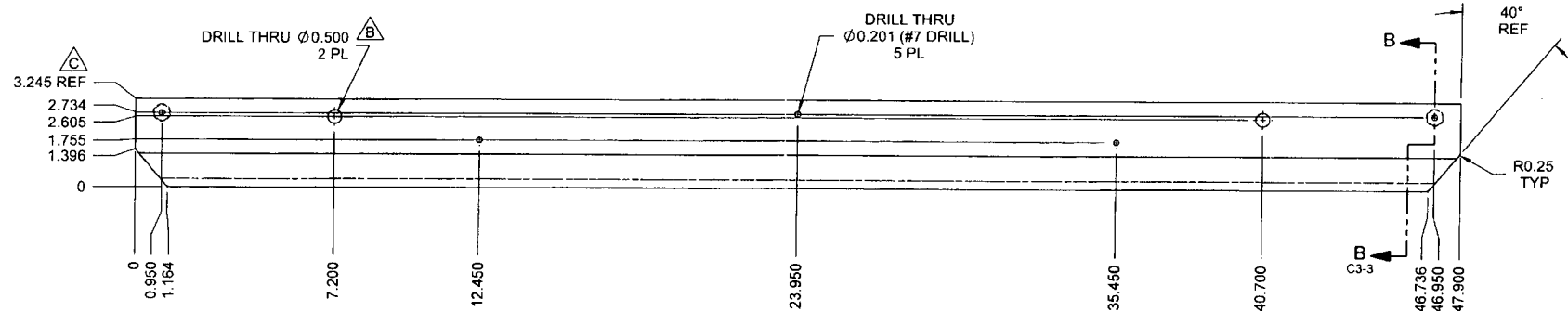
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81542



SECTION B-B B2-3








D3499-3 CABLE GUARD

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. MUHMB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.52 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3499	SHEET 3 OF 4
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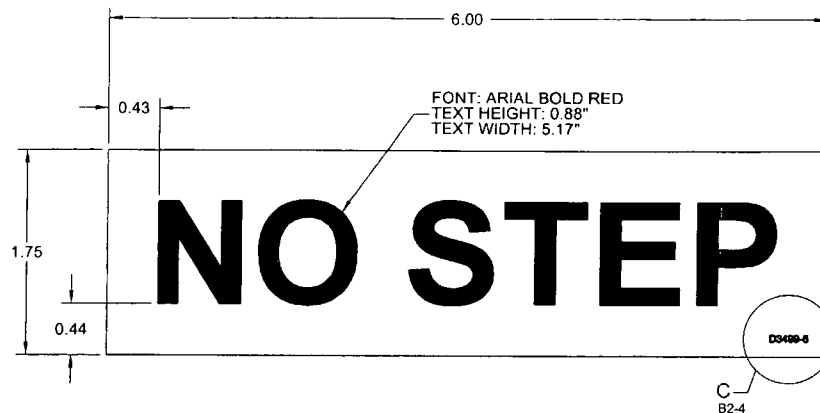
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

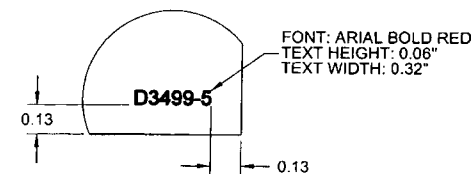
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81542



D3499-5 PLACARD



DETAIL C B5-4
SCALE 2X

RELEASED
2010-02-03
my

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	B	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3499	REV. C
MFG. APPR.		SHEET 4 OF 4	
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